

Date: Friday, 9/21/2007 1:17:52 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE KIT	
Job Number	34809		Part Number	K10003	
Estimate Number	10532		Drawing Number	IIN D205-634 REV D	
P.O. Number	N/A		Project Number	N/A	
This Issue	9/21/2007 S.O. No. N/A		Drawing Revision	D	
Prsht Rev.	NC		Material	N/A	
First Issue	9/21/2007 Type		Due Date	10/20/2007	
Previous Run	34355		Qty:	12 Um: Each	
Written By			13		
Checked & Approved By			12		
Comment	Est: 03.01.16 Rerformat: Incorporated D205-641-011 KJ/RF Est: J 06-07-25 As per DSI 9344 JLM Est: K 06.11.17 Per K10003 Rev C KJ Est Rev: L 07.01.12 Document Record for copying bluefile rmv KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	DC	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Create White labels only per PPP K10003 CHG 005 		
2.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
3.0	D2570	Bushing 
Comment: Qty.: 24.0000 Each(s)/Unit Total: 288.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 24 D2570 Bushing 		
4.0	D2571	Saddle, Fwd, Out 
Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Saddle, Fwd, Out Pick: Qty Part Number Description Batch 1 D2571 Saddle 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: SADDLE KIT
Job Number: 34809			Part Number: K10003
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
5.0	D2572	Saddle, Fwd, In	
			 <i>P10</i>
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)			<i>5 8 56 34749 34750</i>
Saddle, Fwd, In			
Pick:			
Qty	Part Number	Description	Batch
1	D2572	Saddle	<i>34328</i>
6.0	D2573	Saddle, Aft, Out	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)			<i>34369</i>
Saddle, Aft, Out			
Pick:			
Qty	Part Number	Description	Batch
1	D2573	Saddle	<i>34750</i>
7.0	D2574	Saddle, Aft, In	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)			<i>34370</i>
Saddle, Aft, In			
Pick:			
Qty	Part Number	Description	Batch
1	D2574	Saddle	<i>34815</i>
8.0	D27361	Lug Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)			<i>SP</i>
Lug Assembly			
Pick:			
Qty	Part Number	Description	Batch
1	D2736-1	Bracket	<i>34109</i>
9.0	D27363	Lug Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)			
Lug Assembly			
Pick:			
Qty	Part Number	Description	Batch
1	D2736-3	Bracket	<i>33566</i>
			<i>7/10/318P</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: K10003 PAR #: PLA Fault Category: Part Packaging NCR: Yes No DQA: LD Date: 02/11/05
 QA: N/C Closed: TD Date: 07.11.06

NCR: <u>34859</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A <u>B34749</u>	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.01	5.0	3x D2572 were packaged ident. as D2579 B34749. Saddles in form are D2572. R.C: Human error (New employee & assisted by trainer.)	<u>Q5/10/01</u>	re-identify with the correct part #	<u>Q5/10/01</u>	<u>Q5/10/01</u>	<u>Q5/10/01</u>	<u>Q5/10/01</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 34809

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Set Screw

Pick:

Qty

Part Number

Description

Batch

4

D2747

Socket Head Set Screw

33470, SP

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2876

Spacer

029789, SP

PTO

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2877

Spacer

32109, SG

13.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Tow Ring

Pick:

Qty

Part Number

Description

Batch

1

D2968-041

Tow Ring

30274, SG

14.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Set Screw

Batch:

1723170

328093, SG

15.0

AN46A

Bolt



M105057, M104322

Comment: Qty.: 16.0000 Each(s)/Unit Total : 192.0000 Each(s)

Bolt

Pick:

7/10/31 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: K10003 PAR #: 111 Fault Category: Tool/Packaging NCR: Yes No DQA: LD Date: 07/11/05
 QA: N/C Closed: _____ Date: _____

NCR: <u>34805</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-01	110	D2876 B29789, were mis-ident. listed in 4 kits, as D2877 B29789. R.C: Human error	<u>DSIAUZ</u>	re-identify parts correctly	<u>SD</u>	<u>do</u> <u>07/11/01</u>	<u>DSIAUZ</u>	<u>07-10-01</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services				Drawing Name: SADDLE KIT
Job Number: 34809				Part Number: K10003
Job Number: 				
Seq. #:	Machine Or Operation:		Description :	
	Qty	Part Number	Description	Batch
	16	AN4-6A	Bolt	
16.0	AN446A		Bolt	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)				<i>SP</i>
Bolt				
Pick:				
	Qty	Part Number	Description	Batch
	4	AN4-46A	Bolt	<i>M104925</i>
17.0	AN451A		Bolt	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)				<i>SP</i>
Bolt				
Pick:				
	Qty	Part Number	Description	Batch
	8	AN4-51A	Bolt	<i>M105281</i>
18.0	AN612A		Bolt	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)				<i>SP</i>
Bolt				
Pick:				
	Qty	Part Number	Description	Batch
	8	AN6-12A	Bolt	<i>M10558</i>
19.0	AN960JD416		Washer	
Comment: Qty.: 32.0000 Each(s)/Unit Total : 384.0000 Each(s)				<i>SP</i>
Washer				
Pick:				
	Qty	Part Number	Description	Batch
	32	AN960JD416	Washer	<i>M104746</i>
20.0	AN960JD616		Washer	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)				<i>SP</i>
Washer				
Pick:				
	Qty	Part Number	Description	Batch
	8	AN960JD616	Washer	<i>M104745</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SADDLE KIT

Job Number: 34809

Part Number: K10003

Job Number:



Seq. #: Machine Or Operation:

Description :

21.0 AN9704 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch
1 AN970-4 Washer M104885 ✓ SP

22.0 MS21042L4 Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 348.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch
29 MS21042L4 Nut (or MS21042-4) M19099 ✓ 1/10/10 (13)

23.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

24.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MS21042L4

✓ 1/11/10 (13)

25.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

✓ 1/11/10 (13)

Job Completion



✓ 1/11/10 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07	TITLE SADDLE KIT		SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED06.11.07 *PH*

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

WORK ORDER
NO. 34809

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